

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011353**Date Inspected:** 13-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

6CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 021 located at SEG031B on cross beam side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR #9640 repair procedure.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 021 located at SEG031B on cross beam side of segment. Welder is identified as Mr. Bi Shijian (068746). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR #9640 repair procedure.

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6AW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 009 located at SEG029B on counter weight side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR #9729 repair procedure.

5BW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 008 located at OBW5A (internal) on counter weight side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR #1054 repair procedure.

Y Location of repairs areas by above noted welder (054467) are located at 925mm~955, 2065mm~2172, 1380mm, 1410mm and 2572mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 008 located at OBW5A (external) on counter weight side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR #1054 repair procedure.

Y Location of repairs areas by above noted welder (054467) are located at 2571mm, 2172mm and 2168mm.

6BE+6CE

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 013 and 014 located at EP55 side plate on the bike path side of segment. Welder is identified as Mr. Bi Shijian (068764). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

NDT Observation

This QA Inspector observed ZPMC's Magnetic Particle Testing (MT) Technician performed MT on various locations in the trial assembly yard. Locations are as followed:

6AE+5CE

1. Bottom plate stiffeners hold back welds between panel point 36 and 38.

This QA Inspector observed ABF's Ultra Sonic Testing (UT) Technician performed UT on various locations in the trial assembly yard. Locations are as followed:

1. Edge plate to deck plate Complete Joint Penetration (CJP) weld # CA030-002, 003 and 004 on bike path side of

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segment.

6AE

During random in-process visual inspection at Segments 6AE+CB5 cross beam side of segment, this QA Inspector observed UT reject repairs welding being performed without a CWI present on 1-12-10 (1740~1830) work shift. This QA Inspector issued an incident report for noted issue.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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